

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020295**Date Inspected:** 16-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Ping (ZPMC)**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** BAY 14 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A. DeArmond was present during the time noted above and conducted observations relative to the work being performed.

OBG BAY 14

Magnetic Particle Testing (MT)

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 07805. The member(s) is/are identified as Anchorage Plate. The weld designations reviewed are as follows:

AP3020-001-048, 048, 056, 057, 060, 061, 072, 073, 002, 003, 006, 007, 028, 029, 088, 089, 109, and 112

AP3021-001-064, 065, 072, 084, 085, 096, 097, 116, 117, 171, 044, 045, 073, 076, 104, 105, and 108

WELDING INSPECTION REPORT

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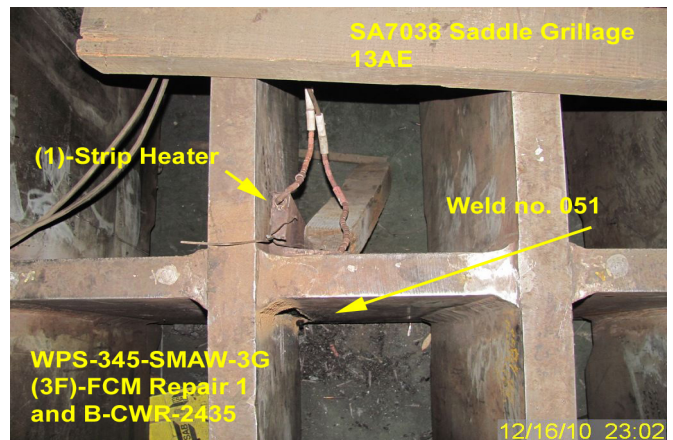
OBG BAY 14

This QA Inspector observed the following work in progress:

ZPMC did not appear to properly preheat prior to performing a critical weld repair. The applicable critical weld repair report (B-CWR-2435 Rev3) specifies a minimum preheat value of 200oC for material thickness greater than 40mm. This QA observed that a 200o C temp stick did not melt within 75mm of the Complete Joint Penetration (CJP) joint being repaired. The weld joint is identified as SA7038-051. The weld is a CJP joint, joining members identified as

1. X3801A to X3788A (SPCM and TTP)
2. Material thickness is 75 mm.
3. Welding process is Shielded Metal Arc Welding (SMAW)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As mentioned above between QA and QC concerning this project

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By: DeArmond,Robert

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer
